

Date: Thursday, 12/20/2007 3:20:03 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER BUSHING
Job Number : 36479	
Estimate Number : 10826	
P.O. Number :	Part Number : D23273
This Issue : 12/20/2007 S.O. No. :	Drawing Number : D2327 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 34589	Material :
Written By :	Due Date : 1/20/2008 Qty: 50 Um: Each
Checked & Approved By : <u>JA 01/22/1</u>	
Comment : Est. F 05.11.02 Removed 303 SS KJ/EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304R0375	304 SS ROUND BAR
-----	-----------	------------------



Comment: Qty.: 0.1641 f(s)/Unit Total: 8.2058 f(s)

Inventory

Material: AISI 304 Round Bar Ø0.375"

(M304R0.375)

Batch:

M106860

H.A. 08/01/19

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327

Deburr

H.A./JML 08/01/19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A./JML 08/01/19

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

BC 08.01.20

FO

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

u 08.01.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:20:03 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 36479

Part Number: D23273

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

508.01.21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

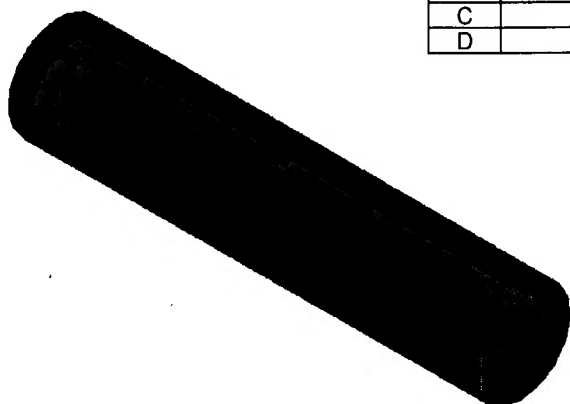
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



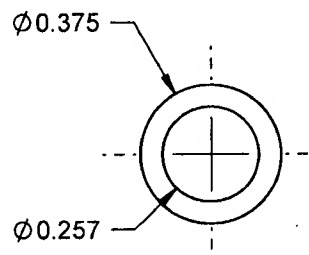
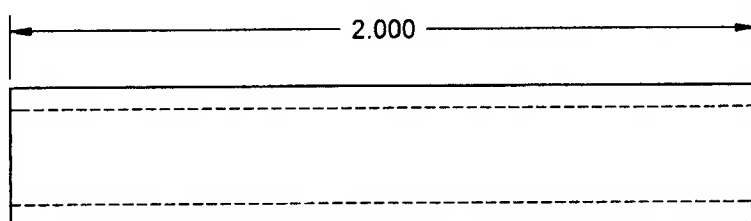


DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>CH</b>	DRAWING NO. <b>D2327</b>	REV. D SHEET 1 OF 1
DATE <b>06.10.12</b>		TITLE <b>SPACER BUSHING</b>	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	

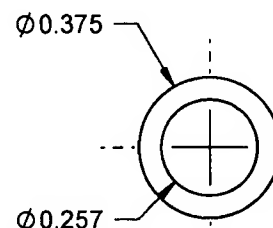
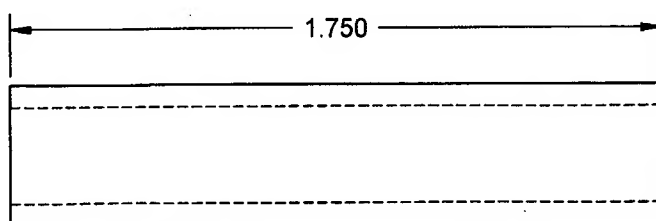


**RELEASED**

06.11.14 **TH**



**D2327-1 SPACER BUSHING**



**D2327-3 SPACER BUSHING**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS,  $\phi 0.375$ , 0.065 WALL SEAMLESS ROUND TUBING  
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **36479**

**COPYRIGHT © 1994 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

